



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D6101-007
Job Sheet 170404



5038648

Part No: D6101-007

Job Qty: 60 ea

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/6/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	60 pcs		2/6/18	0.00	0.00	Purchasing		DAS 11
110	Packaging	60 pcs		2/6/18	0.00	0.00	Packaging2		PD 15-02-03
120	QC	60 pcs		2/6/18	0.00	0.00	QC6		SBL 18/02/04
130	Packaging	60 pcs		2/6/18	0.00	0.00	Packaging3-2		ML5 FEB 03 2018
140	QC21-SA	60 Ea		2/6/18	0.00	0.00	QC21		FEB 05 2018

Part Op 100 - Issue P/O: 03879X b) 7.750" x 8.250" x 2.50" thick d) Grain direction along 7.750" length
Descriptions: 110 - Ensure material certification is attached
120 - Ensure Material certification comply to Dwg D6101
130 - LOCATION: MAT041

JAN 1 2017
JAN 16 2017

Job Allocations

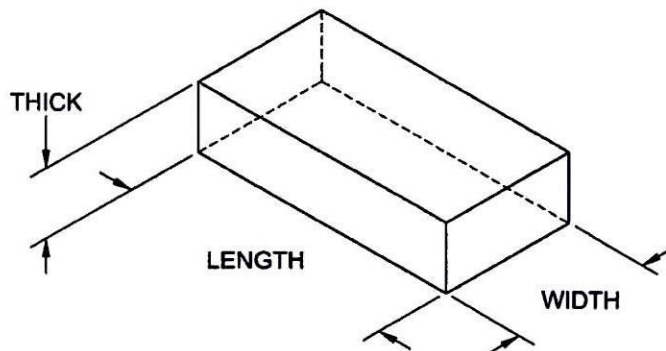
Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D6101-007P	60	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/16/18 9:28 AM dart.baker.diane

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WP

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: DL101-007
DATE: 18/02/03

PO / BATCH NO: 038795/5038648

MATERIAL CERT REC'D yes
QUANTITY RECEIVED 60
QUANTITY INSPECTED 60
QUANTITY REJECTED 0

THICKNESS ORDERED 2.500
THICKNESS RECEIVED 2.500
SHEET SIZE ORDERED N/A
SHEET SIZE RECEIVED N/A

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	☒ Y ☐ N	
CORROSION	Y ☒ N ☐	
CORRECT GRAIN DIRECTION	☒ Y ☐ N	
CORRECT MATERIAL PER M-DRAWING	☒ Y ☐ N	AMS-DD-A-250/12
CORRECT THICKNESS	☒ Y ☐ N	
PHOTO REQUIRED	Y ☒ N ☐	
CORRECT REF # TO LINK CERT	☒ Y ☐ N	HEAT # 406131
CORRECT MATERIAL IDENTIFICATION	☒ Y ☐ N	
CORRECT M# ON THE MATERIAL	☒ Y ☐ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N ☐	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N ☐	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u> <u>11</u> <u>9-89</u>	SIGNED OFF BY: _____		
DATE: <u>FEB 03 2018</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

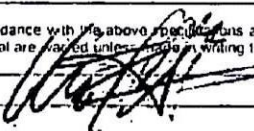
Page 1 of 1

Shipment No:3500985

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 01-FEB-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3500985-2	

Shipment Details	Final Destination Branch - TOR
-------------------------	---------------------------------------

Order No	Line No	Item No	Description				
5017058	2	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI. 8.25" X 7.75" CUT RECTANGLE TO 8.25 IN () X 7.75 IN () SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No		Part Number	Ordered Qty		Invoice Qty		
38795		YOUR ITEM NUMBER: D6101007	60.00 PCS		60.00 PCS		
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
121576577		 4406131		60			991.9012

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.				Reviewed by Authorized Castle Metals Representative 	Date: FEB 01 2018	Name: 
---	--	--	--	---	-----------------------------	---

Date Printed: 01-FEB-2018 02:43:07 PM

CERTIFIED INSPECTION REPORT

Arconic

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material meet the composition limits and have the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

S. H. H. H.
Manufacturing Director - Davenport A. Facilities

T. H. H. H.
Tolerance Team
Quality Assurance Manager

Page 1 of 2

Ship From:

3400984	0			
Ship Date	B.L. No.	Invoice No.	Arconic No.	Item
2018-01-13	11622616	00000	1000966375-4	DP-66375-01-4
P.O. No./Cust. Contract No.	Customer	Arconic Item		
101169 Lnt: 11	HADCO METAL TRADING 0041175305801			

Ship To: HADCO METAL TRADING CO LLC
HADCO METAL TRADING CO LLC
555 STATE RD
ATTN: ACCOUNTS PAYABLE
BENSALAH, PA 19020

Item Description
2.5 IN TK (1.075 -0.075) X 51.5 IN W (+.3125 -0.000) X 147.0 IN LH (1.5 -0.0) (N) A/T 7075-T7351 RECTANGLE MILL FINISH, US1 3MM DEAD ZONE REQ'D BOTH SIDES, SAWED. AMS-STD-2154 REV C AMS4078 REV J CM40025 REV V ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-30 & US1 CL. A 3 MM COR 026075C REV 01 CUST REQ 10-01-01 *** M/E 18-01-C6 ***

RE-CERTIFIED TO AMS QQA 250/17 AND DPS4.713 WITH THE EXCEPTION TO MARKING. CUSTOMER ASSUMES ANY RISK REGARDING HANDLING, STORAGE, OR PROCESSING WHICH MAY HAVE ALTERED PROPERTIES OR PRODUCT FORM FROM THAT AS ORIGINALLY DELIVERED.

Num	Package Ticket	Lot	Weight	Quantity	UCM	Inspector Clock Numbers
1	436199	406131	3834	2	PC	47419
2	436201	406131	4070	2	PC	47419
3	436202	406131	3834	2	PC	47419
			11738	6		

Notes for COR: 0260750.1

THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED USING TYPE 1, UT IMMERSION METHOD.

COR: 0260750.1 -Specification Limits

Temp	Dir	UTS	TYS	EL40
		KSI	KSI	PCT
T7351	Long Transv.	Max	63.9	
		Min	66.0	6

RECERTIFIED
COPY

1/19/18 AL



CERTIFIED INSPECTION REPORT

Arconic

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material meet the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or omissions on this certificate by any recipient may be punished as a felony under applicable law.

For:

S. Mahajan
Hansu Mahajan
Manufacturing Director - Davenport & Bettendorf

James Thom
James Thom
Quality Assurance Manager

Ship From:

3400984	0	Invoice No.	Arconic No.	Item
Ship Date	B.L. No.			
2018-01-13	11622616	00000	1000966375-4	DP-66375-G1-4
P.O. No./Govt Contract No.	Customer	Arconic Item		
101169 Lot: 11	HAECO METAL TRADING	G041175305H01		

Page 2 of 2

COR: 0260750.1 -Specification Limits (cont.)

T7351 Elec. Cond. (EC) & MIN 38.0 PCT

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
		Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05
		Min		1.2		2.1	0.18	5.1			
Alloy	7075										
Lot:	406131										
Mechanical, Physical, Metallography, Quantometer Results											
No ->		UTS	TYS		EL4D						
Temp	Dir	Test	KS1	KS1		PCT					
T7351	Long Transv.	3	71.1	60.2		10.4					
			71.2	60.4		10.3					
			70.9	60		10.2					

T7351 Elec. Cond. MAXS 41.0 41.0 40.9 PCT

Cast Number	Chemical - ORS	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Each	Other	Total
H9440024	Actuals	0.07	0.26	1.6	0.03	2.5	0.19	5.5	0.02	< 0.05	< 0.15		

This material was melted in the United States or a Qualifying Country (REF DFARS 225.872.1(a)); it was manufactured in the United States

**RECERTIFIED
COPY**